| Work Orde Monday, May 02, | r ID 69120 2011 2:07:47 PM | | | | | | H | 100 | <u>5.</u> | Page 1 |
|--------------------------------|---|---|----------------------|--------------|--------|---|---------------|---------------|------------------|----------------|
| Revision ID: Item Name: | O3437-043 Aft Strut Assembly 1/2/2011 Start Qty: 1.00 1/2/2011 Req'd Qty: 1.00 | | Accept | Cust Item II | | | \$ | _ | tart | |
| | Process Plan:QC: | Date: //- Ø-2 | _ | | te: | | R | | 4 | |
| Sequence ID/ Work Center ID | Operation Description | A STATE A CONTROL OF THE STATE | Set Up/ Run Hours | Tool ID | Tool # | | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| Draw Nbr | Revision Nbr | | | | | | | | | |
| D3437 | Rev B | | | | | | | | | |
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| 110 QC Quality Control | QC4- 100% Inspect kit Memo | s for completeness | 0.00 [11] | usluz. | | | (A) | | · | |
| 120 Packaging | ldentify as per dwg & S Mem o | tock Location 508 | 0.00 | | | - | (1 | 14/ | 2 & | 2 |

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| W/O: | | | WO | RK ORDER CHANG | GES | | | | |
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| Part No | : | PAR #: | Fault Cate | gory: | NCR: Ye | s No DC | A: | Date: _ | |
| | R | esolution: | Disposition | 1: | QA: N/C | Closed: | | Date: _ | |
| NCR: | | | WORK ORDE | ER NON-CONFORM | ANCE (NO | CR) | | | |
| | 0:ED | Description of NC | of NC Corrective Actio | | tion B | Verif | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sig Da | n& ∣ _{Sec} | tion C | Chief Eng | QC Inspector |
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Work Order ID 69120



Page 2

Monday, May 02, 2011 2:07:48 PM

Required Date: 5/2/2011

Item ID:

D3437-043

Accept



Setup Start

Stop



Revision ID:

Item Name:

Aft Strut Assembly

Start Date:

5/2/2011

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Set Up/

Run Hours

Date:

Stop

Sequence ID/

Work Center ID

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Memo

QC21- Final Inspection - Work Order Release

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Tool ID

Tool # Plan

Code

Accept Qty

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| | | Resolution: | | | | | | | |
| NCR: | | | WORK OR | DER NON-CONFORMA | NCE (NCR) |) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | Verific | cation | Approval | Approval |
| DATE | SIEF | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Secti | on C | Chief Eng | QC Inspector |
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Picklist Print

Monday, May 02, 2011 2:07:43 PM

Work Order ID: 69120

Parent Item:

D3437-043

Parent Item Name: Aft Strut Assembly

Comments:

A□05.05.20□New Issue□KJ/JLM□



Start Date: 5/2/2011

Required Date: 5/2/2011

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Date Status Issued Issued |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|----------------------------------|
| AN960C516 Washer | | Purchased | No | | | 100 | Each | 54.0000 | 2 | ² | s ulaxlar |
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| 3437-3 *********************************** | 11(1):00(| Manufactured | No | | | 100 | Each | 42.0000 | 1 | 1 | ra 1 |
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| 03437-9 | | Manufactured | No | | | 100 | Each | 11.0000 | 1 | 1 | . 1 |
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Page 1

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| W/O: | | | W | ORK ORDER CHANGI | ES | | | | |
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| Part No | * | PAR #: | Fault Cat | egory: | NCR: Yes | No DQ | A: | Date: _ | |
| | R | esolution: | Dispositi | on: | QA: N/C C | osed: | | Date: | |
| NCR: | | | WORK ORE | DER NON-CONFORMA | NCE (NCF | ₹) | | | |
| DATE | STEP | Description of NC | | Corrective Action Section | | | ification Approval | | Approval |
| DAIL | JILF | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | ion C | Chief Eng | QC Inspector |
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Picklist Print

Monday, May 02, 2011 2:07:43 PM

Work Order ID: 69120

Parent Item:

D3437-043

Parent Item Name: Aft Strut Assembly



Start Date: 5/2/2011

Required Date: 5/2/2011

Page 2

Start Qty: 1.00

Required Qty: 1.00

MS21043-5

Purchased

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| Location | | Loc Qty | Loc Code | |
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| NCR: | | W | ORK OR | DER NON-CONFORMA | NCE | (NCR | 1) | | | |
| DATE | | Description of NC Corrective Action Section B | | | | | Verific | cation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | on C | Chief Eng | QC Inspector |
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| | | 一概 | | D3437 | SHEET 1 OF 4 |
| ı | DATE | | | TITLE | SCALE |
| | | 05.0 | 8.11 | AFT STRUT ASSEMBLY | 1:2 |
| | Α | 0 | 5.04.29 | NEW ISSUE | |
| | 8 | 0 | 5.08.11 | UPDATE D3437-5/-9/-11 DIMENSION | NS |

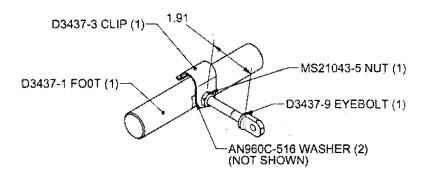
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D3437-3 CLIP (1)

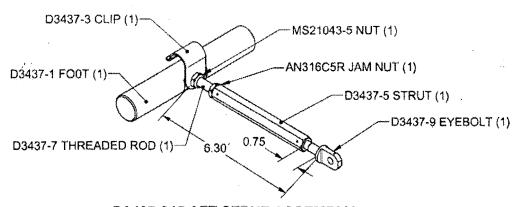
D3437-1 FOOT (1)

D3437-11 EYEBOLT (1)

D3437-041 AFT STRUT ASSEMBLY



D3437-043 AFT STRUT ASSEMBLY



D3437-045 AFT STRUT ASSEMBLY

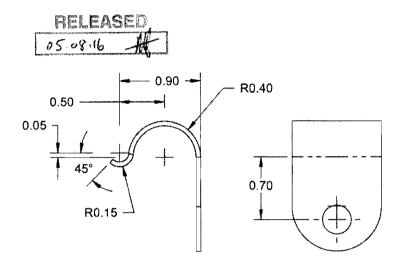
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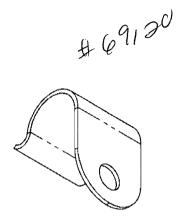
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| NCR: | | , | WORK ORD | ER NON-CONFORM | ANCE (NCR |) | | | |
| DATE | OTED | Description of NC Corrective Action | | | tion B | Verific | ation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section | | Chief Eng | QC Inspector |
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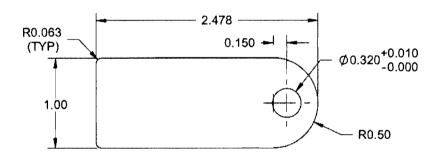


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| 05. | 08.11 | AFT STRUT ASSEMBLY | 1:2 |





D3437-3 CLIP SCALE 1:1



D3437-3 FLAT PATTERN

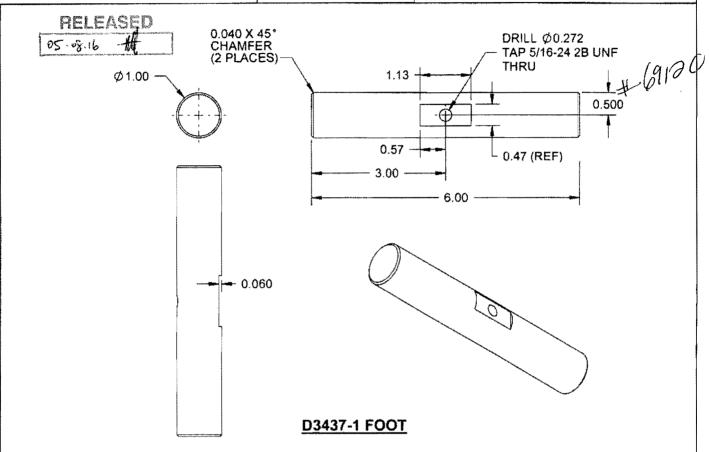
D3437-3 CLIP:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.050 THICK (REF DART SPEC M304S18GA) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

| W/O: | | | W | ORK ORDER CHANG | GES | | | | |
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| NCR: | | , | WORK ORD | ER NON-CONFORM | ANCE (NC | R) | | | • |
| | 0755 | Description of NC Corrective Action | | | ction B | Verific | ation | Approval | Approval |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign Date | & Section | | Chief Eng | QC Inspector |
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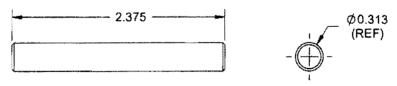


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| 世 | 4 | D3437 | SHEET 3 OF 4 |
| DATE | | TITLE | SCALE |
| 05.0 | 8.11 | AFT STRUT ASSEMBLY | 1:2 |



D3437-1 FOOT:

- 1) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) ALUMINUM ROUND BAR (REF. DART SPEC M6061T6R)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-7 THREADED ROD

D3437-7 THREADED ROD:

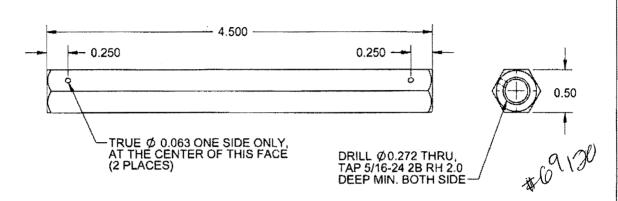
- 1) POSSIBLE SUPPLIER: HASKINS-SPAENAUR P/N 870-832 18-8 5/16-24 SS THREADED ROD
- 3) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| W/O: | | | W | ORK ORDER CHANGI | ES | | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | | |
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| | | | Fault Category: No. | | | | | | | | |
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| DATE | STEP | Description of NC | Corrective Action Section B Initial Action Description | | on B Sign & | | Verification Ap | | Approval | | |
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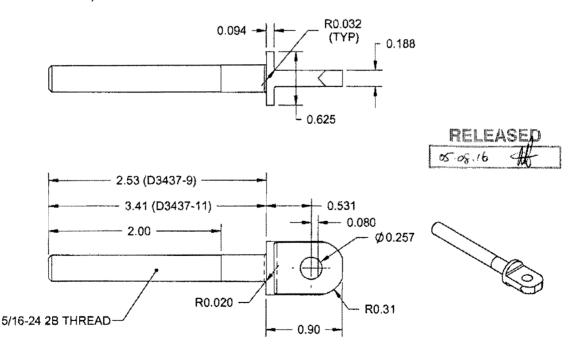


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| DATE | | | TITLE | SCALE | | | |
| 05.08.11 | | | AFT STRUT ASSEMBLY | 1:2 | | | |



D3437-5 STRUT:

- 1) MATERIAL: AISI 303 STAINLESS HEX BAR (DART REF. SPEC M303H0.500) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



D3437-9/-11 EYEBOLT:

- 1) MATERIAL: AISI 303 STAINLESS ROUND BAR (DART REF. SPEC M303R)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 3) ALL DIMENSIONS ARE IN INCHES
 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| Part No: | | PAR #: | Fault Category: | | NCR: Yes No DQA: | | | Date: | | |
| Resolution: | | esolution: | Disposition: Q | | | A: N/C Closed: | | | Date: | |
| NCR: WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | | |
| DATE STEP | | Description of NC | Description of NC | | n B | verification | | | | |
| | O I C I | Section A | Initial Chief Eng | Action Description Chief Eng | Sigi Da | | Section C | Chief Eng | QC Inspector | |
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